Work Order ID 116064

Friday, April 04, 2014 2:02:29 PM

116064

Item ID: D4149-041 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID:

Item Name: Aft X-Tube Lug Ass'Y **Stop** *NS2*

Start Date: 4/30/14 **Start Qty:** 4.00 *4* **Cust Item ID:**

Required Date: 4/30/14 **Req'd Qty:** 4.00 *4* **Customer:**

Reference:

Approvals: **Process Plan:** MCJ **Date:** 14-04-09 **Tooling:** _____ **Date:** _____ **Run Start** *NR1*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr: D4149 / Revision Nbr: C									
100		0.00							
100									
Small Fab	**Memo**	0.00							
Small Fab	1- Assemble as per dwg					QX			14/07/23 DAS 38 9-89
110	QC5- Inspect part completeness to step on W/O	0.00							
110									
QC	**Memo**	0.00				4			
Quality Control									DAS 27 9-89 14/7/23
120	Identify as per dwg & Stock Location: St539	0.00							
120									
Packaging	**Memo**	0.00				4			
Packaging									DAS 33 9-89 14-07-23

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other _____

Item ID: D4149-041
Revision ID:
Item Name: Aft X-Tube Lug Ass'Y
Start Date: 4/30/14 **Start Qty:** 4.00 *4*
Required Date: 4/30/14 **Req'd Qty:** 4.00 *4*
Reference:

Accept *N900040100*
Setup Start *NS1*
Stop *NS2*
Cust Item ID:
Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21- Final Inspection - Work Order Release	0.00							
130 QC Quality Control	**Memo**	0.00				MLJ 140724			

MF 14-7-23

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐				
Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐				
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐				
Large Fab ☐	Composite ☐	Supplier ☐	☐				

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric
- ☐ Cracks
- ☐ Crimp/Kink/Ripple/Wave
- ☐ Cuffs
- ☐ Crushing
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Marks/Chatter
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damage/Defect
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drawing
- ☐ Drill Holes
- ☐ Finish
- ☐ Fit/Function
- ☐ Folio/Program
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete/Unqualified
- ☐ Instructions Incomplete/Unclear
- ☐ Misaligned/off center
- ☐ Mislabeled
- ☐ Misread
- ☐ Off-set
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Set-up
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

Picklist Print

Friday, April 04, 2014 2:02:29 PM

Work Order ID: 116064 *116064*

Parent Item: D4149-041 *D4149-041*

Parent Item Name: Aft X-Tube Lug Ass'Y

Start Date: 4/30/14 **Required Date:** 4/30/14

Start Qty: 4.00 **Required Qty:** 4.00

Comments: IPP Rev:A 10.06.24 new issue DD verf:EC
IPP Rev:B 10.07.22 as per revB DD verf:JLM IPP Rev:C
11.03.03 as per revC DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS21043-3 *MS21043-3* Nut		Purchased	No			100	Each	969.0000	4 **	8	8	14/04/23	DA 3(9-8

Location	Loc Qty	Loc Code
FG	80	
103691	80	
ST315	40	
124555	27	
m126741	13	
ST509	849	
m128398	849	

B M129521 (8x)

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS21043-4 *MS21043-4* Nut		Purchased	No			100	Each	1,380.000	1 **	12	12	14/04/23	DA 3(9-8

Location	Loc Qty	Loc Code
FG	40	
104603	40	
ST315	302	
m123021	12	
m128429	290	
ST509	1038	
m127255	38	
m128300	1000	

M128798 (12x)

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design ☐									
Doc/Data ☐									
Equip/Tooling ☐									
Handling/Pre ☐									
Material ☐									
Operator ☐									
Offset/Setup ☐									
Process ☐									
Supplier ☐									
Training ☐									
Transport ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
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☐ Part Moved
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☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Picklist Print

Friday, April 04, 2014 2:02:29 PM

Work Order ID: 116064

116064

Parent Item: D4149-041

D4149-041

Parent Item Name: Aft X-Tube Lug Ass'Y

Start Date: 4/30/14 **Required Date:** 4/30/14

Start Qty: 4.00 **Required Qty:** 4.00

D3910-1	Manufactured	No		100	Each	52.0000	1	4	DAS 36 9-89 14/07/23
D3910-1							**		
Crosstube Lug									

Location		Loc Qty	Loc Code
ST464		52	
	110135	22	
	113285	30	4

D4091-1	Manufactured	No		100	Each	48.0000	1	4	DAS 36 9-89 14/07/23
D4091-1							**		
Mounting Lug									

Location		Loc Qty	Loc Code
ST142		16	
	113654	16	2
ST144		32	
	110139	12	
	112325	20	2

D4149-1	Manufactured	No		100	Each	0.0000	2	8	DAS 36 9-89 14/07/23
D4149-1							**		
Crosstube Lug Plate, Aft									
D4149-3	Manufactured	No		100	Each	27.0000	1	4	DAS 36 9-89 14/07/23
D4149-3							**		
Spacer									

B119858 (6X)

Location		Loc Qty	Loc Code
ST145		27	
	103576	1	
	108457	6	
	112441	20	1

B116037 (3X)

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

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☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
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☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Work Order ID: 116064

116064

Parent Item: D4149-041

D4149-041

Parent Item Name: Aft X-Tube Lug Ass'Y

Start Date: 4/30/14 **Required Date:** 4/30/14

Start Qty: 4.00 **Required Qty:** 4.00

D4149-5	Manufactured	No		100	Each	28.0000	1	4	DAS 3(; 9-8J
D4149-5						**		14/07/23	
Eyebolt Stud								B121475 (3x)	

Location		Loc Qty	Loc Code	
ST145		28		
	105617	28		1

AN3C12A	Purchased	No		100	Each	574.0000	2	8	DAS 3(; 9-8J
AN3C12A						**		14/07/23	
Bolt									

Location		Loc Qty	Loc Code	
ST351		74		
	M127743	74		
ST513		500		
	M128727	500		8

AN4C13A	Purchased	No		100	Each	426.0000	3	12	DAS 3(; 9-8J
AN4C13A						**		14/07/23	
BOLT									

Location		Loc Qty	Loc Code	
ST356		231		
	m128429	231		
ST513		185		
	m127815	185		12
ST514		10		
	124805	10		

DQA: _____ Date: _____

DART AEROSPACE

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
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General

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☐ Contamination
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☐ Cut Too Short
☐ Drawing
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☐ Fit/Function

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☐ Hardware
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☐ Power Loss/Surge

☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

☐ Other

Work Order ID: 116064
116064
Parent Item: D4149-041
D4149-041
Parent Item Name: Aft X-Tube Lug Ass'Y

Start Date: 4/30/14 **Required Date:** 4/30/14
Start Qty: 4.00 **Required Qty:** 4.00

MS20615-4M18	Purchased	No		100	Each	466.0000	3	12

MS20615-4M18
Rivet

Location	Loc Qty	Loc Code	
ST312	466		
125162	107		
m127580	9		
m127813	232		12
m128429	118		

NAS1149C0332R	Purchased	No		100	Each	9,268.000	4	16

NAS1149C0332R
WASHER

Location	Loc Qty	Loc Code	
GA	981		
125654	981		16
ST292	4952		
m128591	4952		
st510	3335		
m126319	61		
m127306	2500		
m127410	748		
m127831	26		

DQA: _____ Date: _____

DART AEROSPACE

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

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☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

☐ Other _____

Work Order ID: 116064
116064
Parent Item: D4149-041
D4149-041
Parent Item Name: Aft X-Tube Lug Ass'Y

Start Date: 4/30/14 **Required Date:** 4/30/14
Start Qty: 4.00 **Required Qty:** 4.00

NAS1149C0432R	Purchased	No	100	Each	4,198.000	6	24	DAS 3[illegible] 98[illegible]

NAS1149C0432R
WASHER

**

14/07/23

Location		Loc Qty	Loc Code
GA		1719	
	m125807	1719	
ST292		88	
	119124	6	
	121255	3	
	122441	79	
ST510a		2391	
	m126221	2391	

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DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
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☐ Crimp/Kink/Ripple/Wave
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☐ BOM/Route
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☐ Wrong Stock Pulled
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